

Work Order ID 64794

Friday, December 17, 2010 7:56:00 AM



Page 1

Item ID: D3295-041

Accept



Setup Start



Revision ID:

Item Name: Floor Window

Stop



Start Date: 12/16/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

10-2-17

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3295

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3295 ☐ Dwg Rev: *D* ☐ Prog Rev: *D* ☐ 2-
Remove plastic and wrap in saran wrap. ☐ 2-Debur if necessary

LEKKA

RB 10-12-21

(8)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

RB 10-12-21

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8 12/12/22

(79)

*no scratch, no blow outs, no chips
Found 8/12/22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64794

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Page 2

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Setup Start



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Item Name: Floor Window

Start Date: 12/16/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3295. ☐ Put window in plastic wrap.

11/01/12

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Sub 113

x7

N

Pro →

150

0.00



Identify as per dwg & Stock Location: 212

Packaging

Memo

0.00

Packaging

11/01/14 (7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3295-041 PAR #: _____ Fault Category: Small Fab NCR: (Yes) No DQA: [Signature] Date: 11/01/13
 Resolution: _____ Disposition: _____ QA: N/C Closed: [Signature] Date: 11/01/13

NCR: <u>64794</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/01/13</u>	<u>#130</u>	<u>Approx. 1" scratch found on Bottom side of window R.C. handling / Process 1x D3295-041 B64794 Scraps</u>	<u>[Signature]</u>	<u>Scraps window: cannot re-work window to remove the small scratch. Excess cannot be polished.</u>	<u>11/11/13</u>	<u>[Signature]</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>11/21/13</u>

NOTE: Date & initial all entries

Work Order ID 64794

Friday, December 17, 2010 7:56:00 AM



Page 3

Item ID: D3295-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Window

Start Date: 12/16/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/14 J

U 11.01.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, December 17, 2010 7:56:04 AM

Page 1

Work Order ID: 64794

Parent Item: D3295-041

Parent Item Name: Floor Window





Start Date: 12/16/2010

Required Date: 1/19/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP C05.06.200D3295-1 no longer made in-house KJ/JLM
IPP Rev:D Added DT8822 07-03-20 JLM
IPP Rev:E Returned Manufacturing In House 07-06-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2728-1 		Manufactured	No			100	Each	0.0000	0	0			
Dart Logo label													
MLEXS.125-9034-01 		Purchased	No			140	sf	106.6500	1.24	7.831579			
1/8" 9034 Lexan Sheet													

B39012



8

BB

11/01/12



B10-12-21

Location

Loc Qty

Loc Code

MAT

106.65

106173

4

106403

8.65

115861

94

115861

8

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	64794
Description: Window		Part Number:	D3295
Inspection Dwg: D3295 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.156	+0.005/-0.001	.157	*		BU02	
17.13	+/-0.030	17.13	*		T B01	
10.43	+/-0.030	10.43	*		T	
14.35	+/-0.030	14.35	*		T	
8.98	+/-0.030	8.98	*		T	
0.625	+/-0.010	.625	*		V	
7.109	+/-0.010	7.109	*		T	
15.845	+/-0.010	15.845	*		T	
2.308	+/-0.010	2.306	*		T	
5.420	+/-0.010	5.420	*		T	
9.402	+/-0.010	9.402	*		T	
1.312	+/-0.010	1.312	*		V	
6.260	+/-0.010	6.256	*		V	
12.520	+/-0.010	12.520	*		T	
0.313	+/-0.010	.307	*		V	
3.750	+/-0.010	3.750	*		T	
8.150	+/-0.010	8.150	*		T	
9.006	+/-0.010	9.003	*		T	
0.125	+/-0.010	.117	*		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-12-21	Date: 10/12/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	P/O D3295-041 KJ/EC/DD	[Signature]

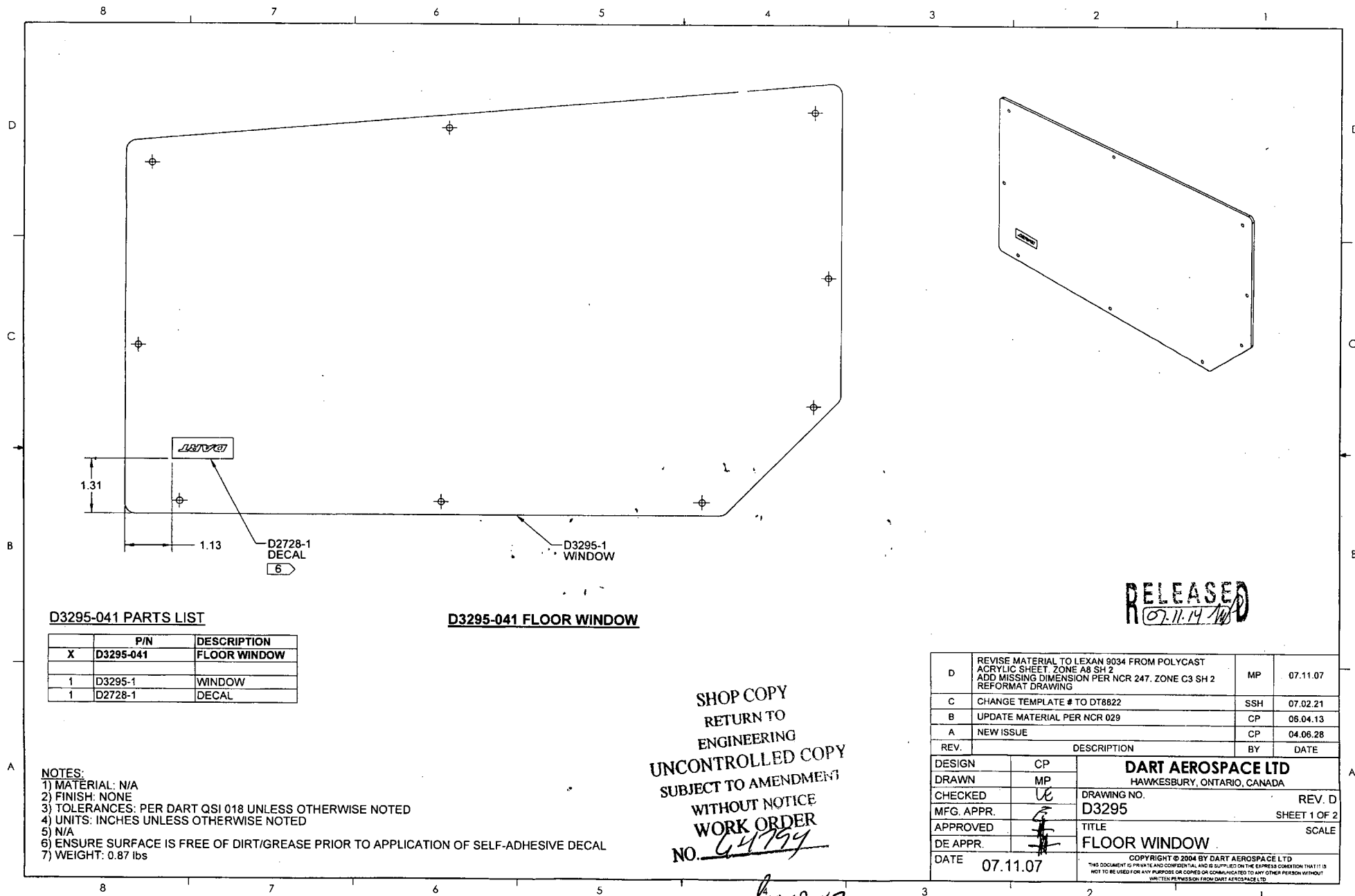
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D3295-041 PARTS LIST

	P/N	DESCRIPTION
X	D3295-041	FLOOR WINDOW
1	D3295-1	WINDOW
1	D2728-1	DECAL

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) N/A
- 6) ENSURE SURFACE IS FREE OF DIRT/GREASE PRIOR TO APPLICATION OF SELF-ADHESIVE DECAL
- 7) WEIGHT: 0.87 lbs

D3295-041 FLOOR WINDOW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 64794

RELEASED
07.11.14

D	REVISE MATERIAL TO LEXAN 3034 FROM POLYCAST ACRYLIC SHEET, ZONE A8 SH 2 ADD MISSING DIMENSION PER NCR 247, ZONE C3 SH 2 REFORMAT DRAWING	MP	07.11.07
C	CHANGE TEMPLATE # TO DT8822	SSH	07.02.21
B	UPDATE MATERIAL PER NCR 029	CP	06.04.13
A	NEW ISSUE	CP	04.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MP		
CHECKED	U	DRAWING NO.	REV. D
MFG. APPR.	5	D3295	SHEET 1 OF 2
APPROVED	5	TITLE	SCALE
DE APPR.	5	FLOOR WINDOW	
DATE	07.11.07	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

2801217

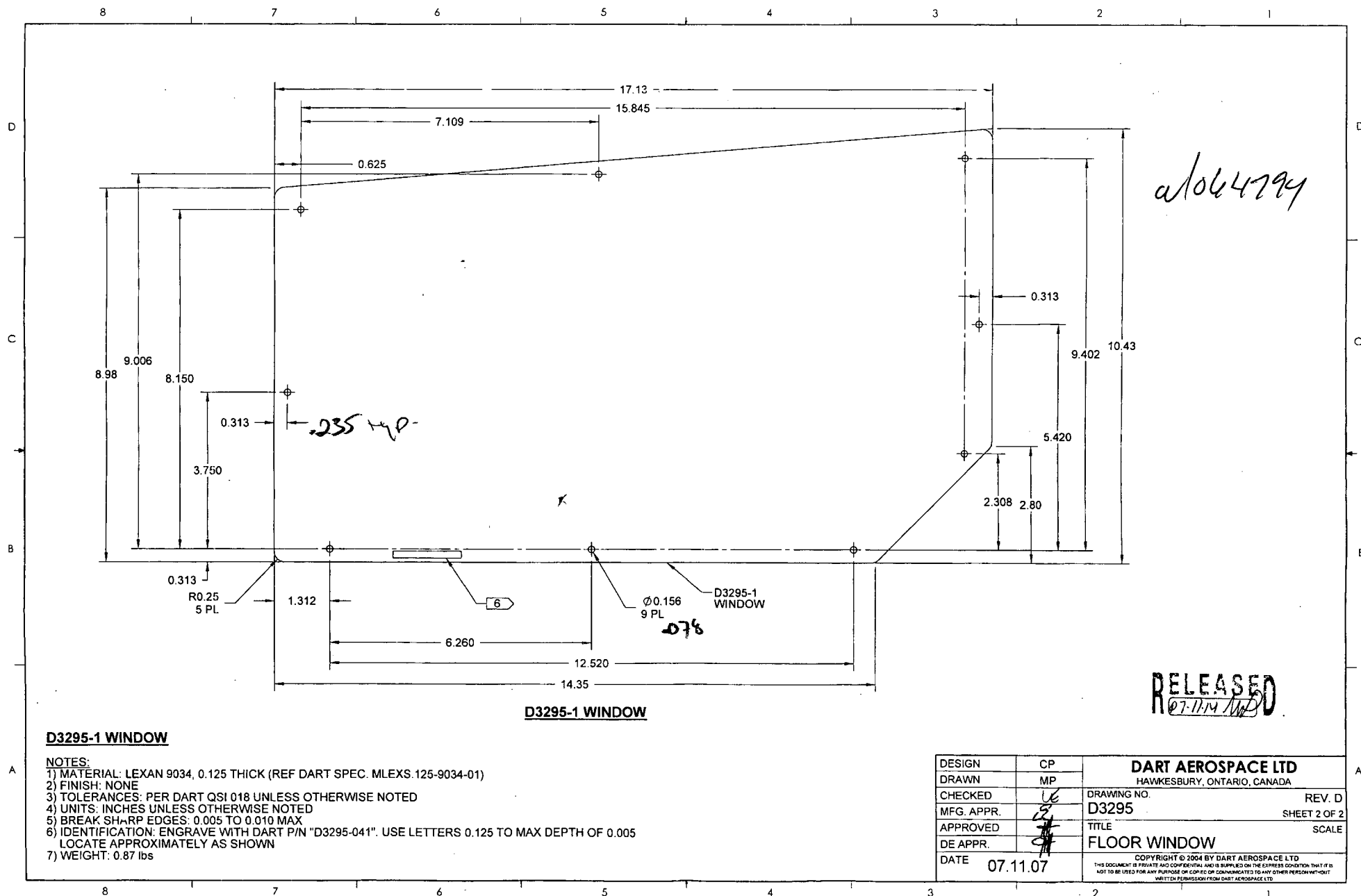
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